














Date: Friday, 02/02/2007 1:48:51 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ADAPTER
Job Number : 30627	
Estimate Number : 12673	
P.O. Number : N/A	Part Number : D35731
This Issue : 02/02/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW <i>FE</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <i>EE</i>	Due Date : 09/02/2007 Qty: <i>9</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-01-29 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6B0500X02500 6061-T6 Bar .50" x 2.5"
 	
Comment: Qty.: 0.3066 f(s)/Unit Total : 1.8396 f(s) 6061-T6 Bar .50" x 2.5" Batch: <i>118530</i> <i>S.F 07/02/07</i>	
2.0	BAND SAW BAND SAW
 	
Comment: BAND SAW Cut blank 3.500" long <i>S.F 07/02/07</i>	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
 	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA672 and Dwg D3573 <i>S.F 07/02/07</i>	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>S.F 07/02/07</i>	
5.0	QC8 SECOND CHECK
 	
Comment: SECOND CHECK <i>En 07/02/07</i>	
6.0	HAND FINISHING1 HAND FINISHING RESOURCE #1
 	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>SS/a.m 07/02/07</i>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 42 Date: 07/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ADAPTER

Job Number: 30627

Part Number: D35731

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

A.M 07/02/07

(9)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 7/02/08 (9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: J.L.V.C

P 7/02/08 (9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P 07/02/08

(9)

Job Completion



U 07.02.08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

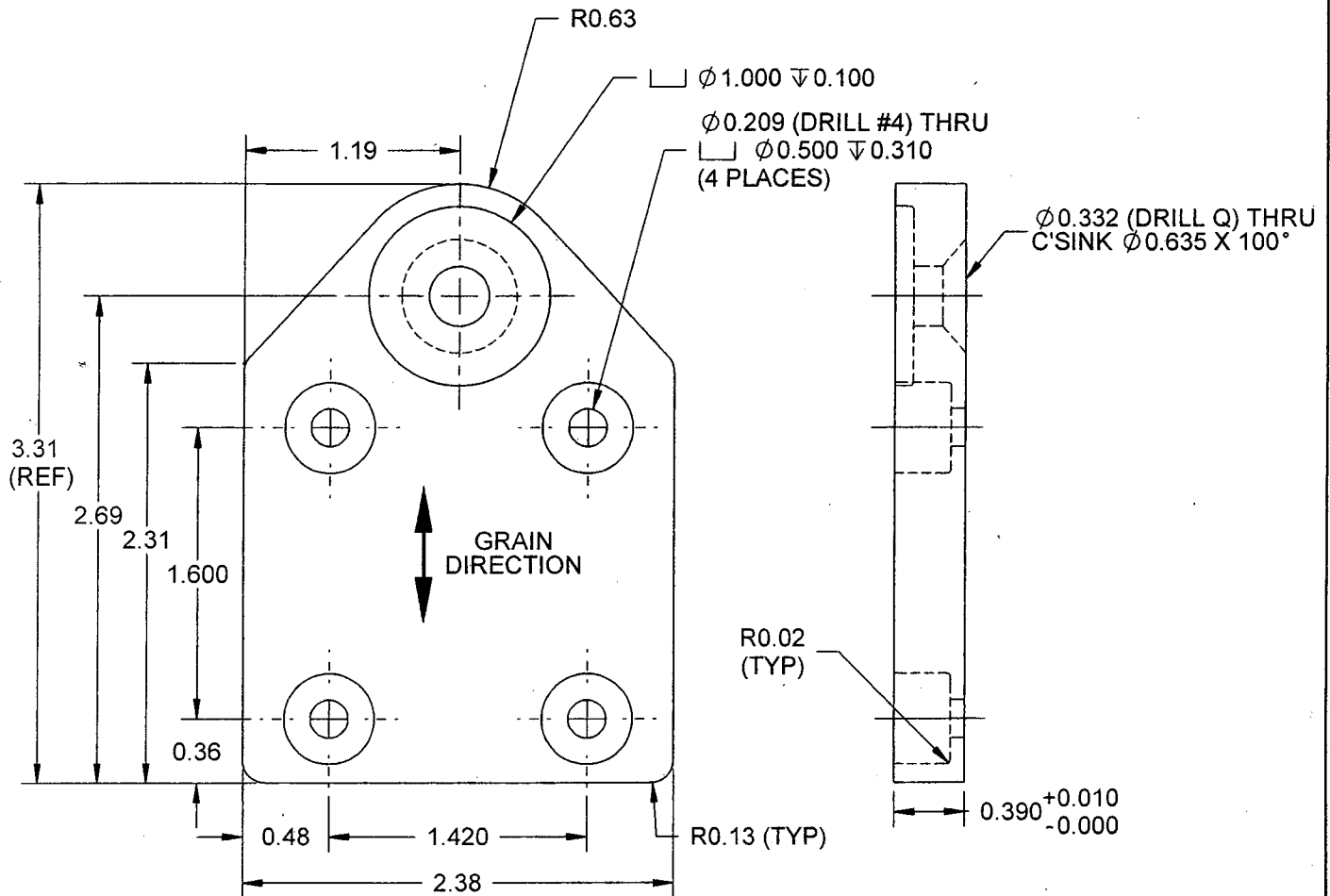
NOTE: Date & initial all entries

PRELIMINARY ISSUE

UNDER REVIEW

07.01.26 CE

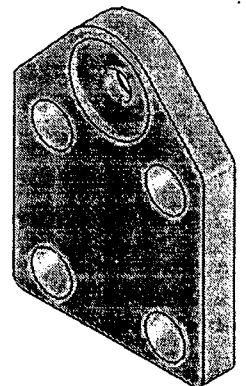
DESIGN LE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3573	REV. A SHEET 1 OF 3
DATE 06.12.07	TITLE ADAPTER		SCALE 1:1
REV A	DATE 06.12.07	DESCRIPTION NEW ISSUE	



D3573-1 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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DART AEROSPACE LTD		Work Order: 30687
Description: ADAPTER		Part Number: 035731
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	Ref	3.300	✓			
2.69	±.030	2.686	✓			
2.310	±.030	2.310				
1.600	±.010	1.600				
0.36	±.030	.354				
1.190	±.030	1.190				
2.38	±.030	2.375				
1.420	±.010	1.420				
.48	±.030	.475				
CB.500 I .310	±.010	.490 x .312				
CB.100 I .100	±.010	.915 x .102				
CS.635 x 100°	±.010	.620 x 100°				
R0.63	±.030	.63				
R0.13	±.030	.130				
R0.02	±.030	.02				
Ø.209	±.005	.209				
Ø.332	±.006	.333				
0.390	±.010	.392				

Measured by: J.F.	Audited by: EN	Prototype Approval: LE
Date: 07/02/07	Date: 07/02/07	Date: 07-03-15

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	